



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RBE117-80168-W1-1
Job Sheet 185492



2364
NOV. 12

Part No: RBE117-80168-W1-1

Job Qty: 5 ea

Part Name: Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/29/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE117-80168-W1 Rev.1A IPP Rev. A 18.10.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-2		Fixed 18-11-8
110	Lathe Conv	5 pcs	11/9/18	11/9/18	0.00	1.25	Lathe Conv-1		Fixed 18-11-9
120	QC	5 pcs	11/9/18	11/9/18	0.00	0.00	QC2 Machining-4		Fixed 18-11-9
130	QC	5 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-4		Fixed 18-11-12
140	Packaging	5 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1		17/10
150	QC21-SA	5 Ea	11/9/18	11/9/18	0.00	0.00	QC21		NOV 20 2018

Part Op 110 - 1-Machine as per DWG. DWG REV: _____ 2-Deburr
Descriptions: 130 - Engrave T/N and 1/3 using MARKTRONIC engraver as per DWG.

GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R1.500	304 Round Bar 1.500	.3450 ft (.069 ea)	90-Start up Operation	S100768

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R1.500	0	32	0

Part Specifications

Specifications could not be found.



Container No: S126156



Part: RBE117-80168-W1-1

Job No: 185492

Serial No/Batch: S126156

Revision: 1A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/08/18

Plex 10/29/18 10:41 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

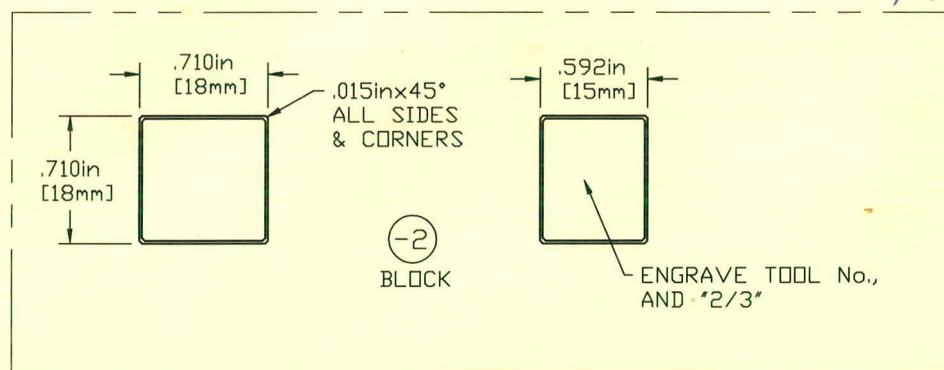
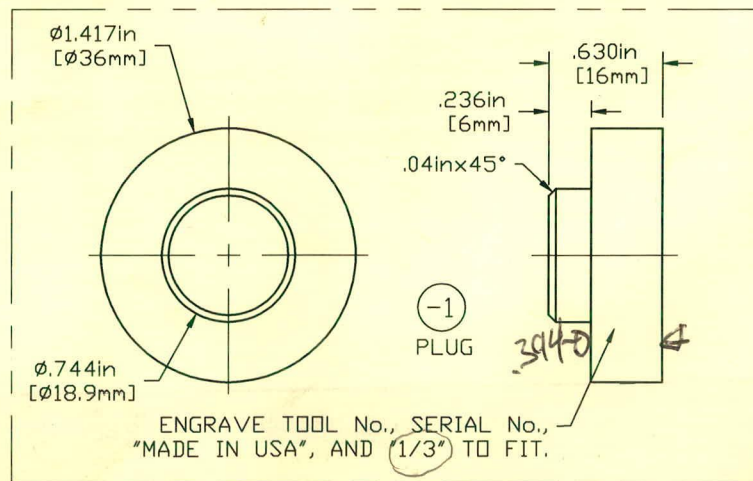
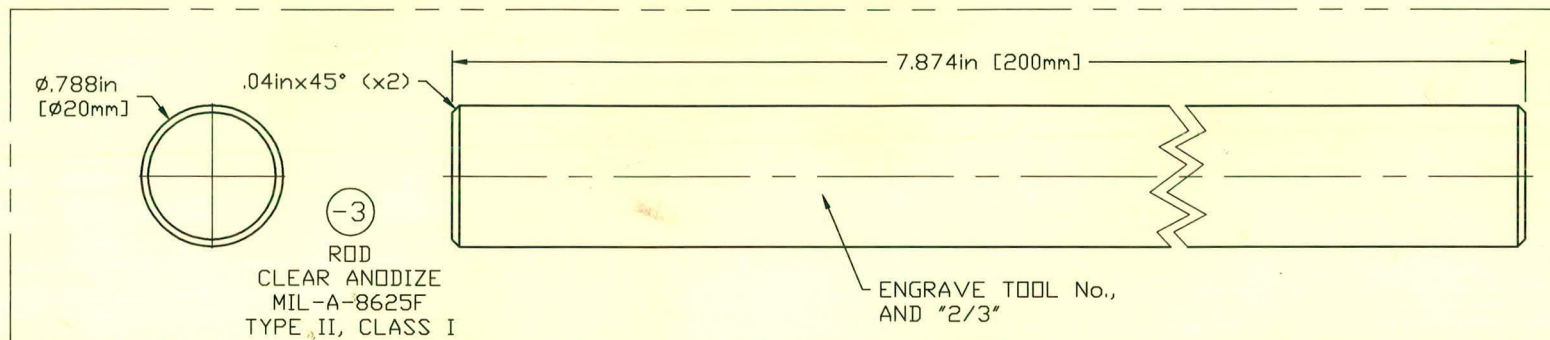
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL / APPROVED
1	ADDED -1 AND -3 TO COMPLETE THE TOOL SET.	7/8/10	WP
1A	CH'D FINISH SPECIFICATION PER R.W.	7/26/10	RJC RW



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185492 MJS 18-10-29

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
			-1	1	PLUG	303/304	Ø1-1/2 x 3/4
			-2	1	BLOCK	303/304	3/4 x 3/4 x 3/4
			-3	1	ROD	6061	Ø3/4 x 8

RED BARN MACHINE	
TITLE M/R HUB PUSH OUT TOOL	
DWG NO. RBE117-80168-W1	REV 1A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS ± 1/32
.XXX ± .005	ANGLES ± 5°
.XX ± .01	
.X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 6-22-09
SHEET 1 of 1	

DRAWN BY: PERRITT
APPROVED: *D. Wood*
HEAT TREAT: SEE PART
FINISH SPEC: EUROCOPTER 145
USED ON MODEL

